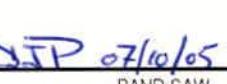


Slip Oct 15

Split  
80 of 101 4Date: Friday, 9/21/2007 1:19:01 PM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	UPPER AND LOWER PLATE		
Job Number	34824		Part Number	D3524041		
Estimate Number	12838		Drawing Number	UNDER REVIEW D3524		
P.O. Number	N/A		Project Number	N/A		
This Issue	9/21/2007	S.O. No.	N/A	Drawing Revision	A	
Prsht Rev.	NC		Material	N/A		AD07/09/24 EC
First Issue	9/21/2007	Type	MACHINED PARTS	Due Date	10/12/2007	Qty: 8 Um: Each
Previous Run	33303					20
Written By						
Checked & Approved By	<u>U</u>					
Comment	Est Rev:A New Issue 07-04-18 EC					
Additional Product						
Job Number: 						
Seq. #:	Machine Or Operation:	Description :				
1.0	M6061T6B0375X03000	6061T6 BAR .375 X 3.00 				
Comment: Qty.: 0.3236 f(s)/Unit Total : 1.6181 f(s) 6061-T6 Bar ..375" X 3.00" batch: M105225  20						NO BATCH# IN COMPUTER
2.0	BAND SAW	BAND SAW 				
Comment: BAND SAW Cut blank 3.700 " long  20						
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 				
Comment: HAAS CNC VERTICAL MACHINING #1						
1- Mill as per Folio FA700 Rev: AA & Dwg D3524Rev: A  20						
2-Deburr per dwg D3443  20						
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 				
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  20						
5.0	QC8	SECOND CHECK 				
Comment: SECOND CHECK  20						

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/01/11	11	Split WO			Sts	07/01/11	3		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: AP Date: 07/10/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:19:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER AND LOWER PLATE

Job Number: 34824

Part Number: D3524041

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

D 21/024

Job Completion



U 07.10.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

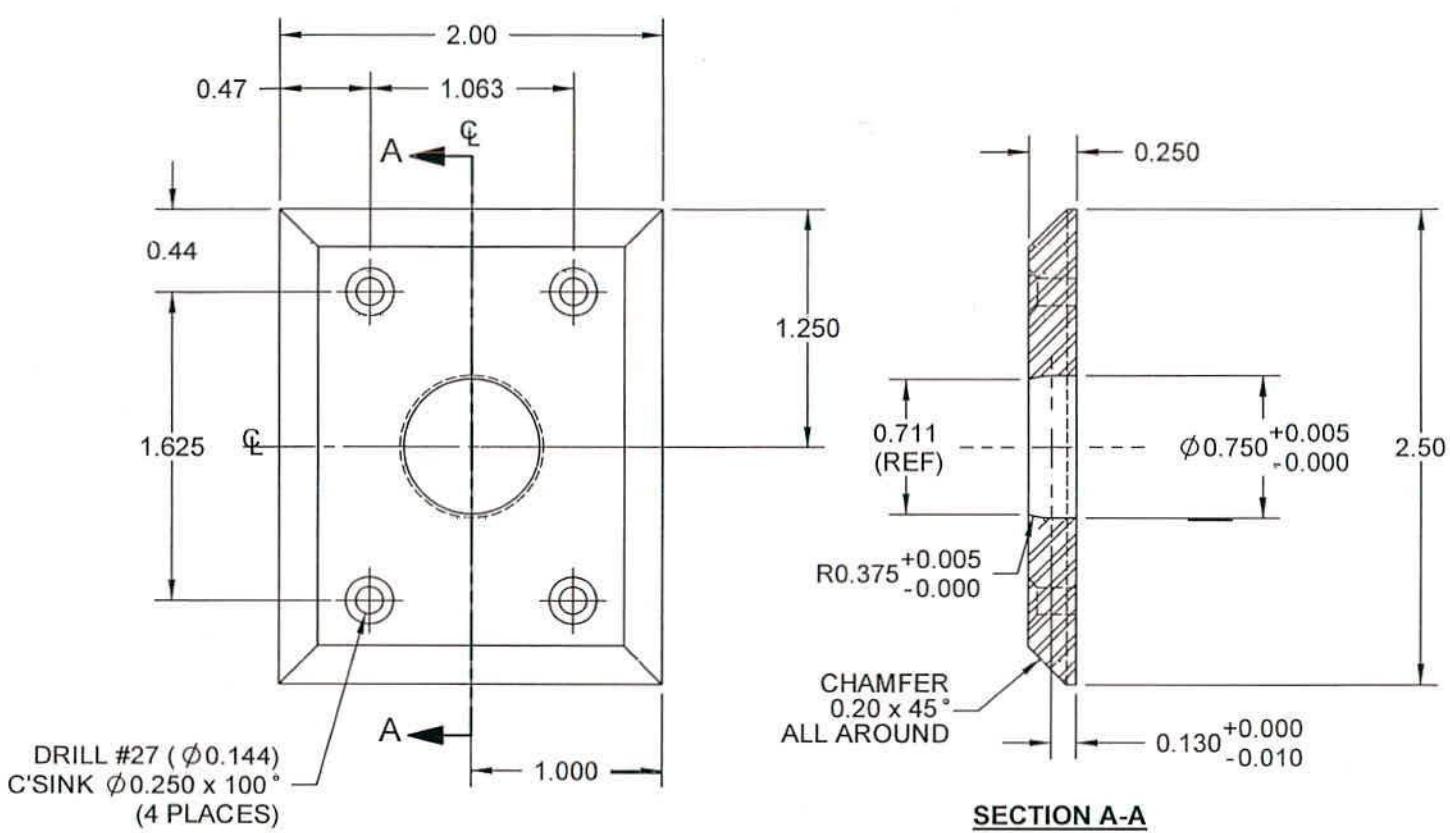
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D3524	REV. A	SHEET 1 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1	
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE		

D3524-1 LOWER PLATE**RELEASED**  
07-08-03 *[Signature]*NOTES:

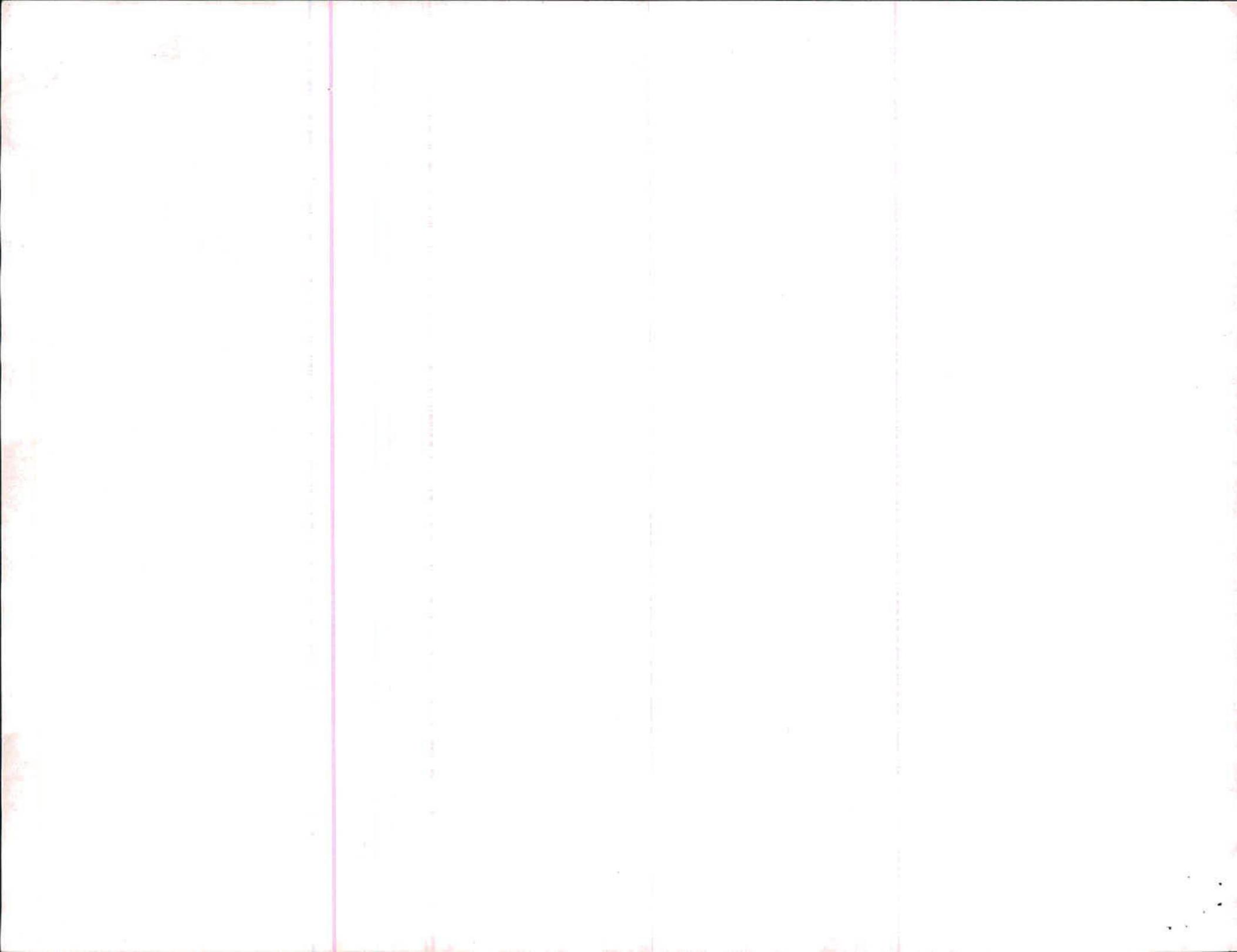
- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT  $\frac{C}{2}$

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WORK ORDER

NO. \_\_\_\_\_

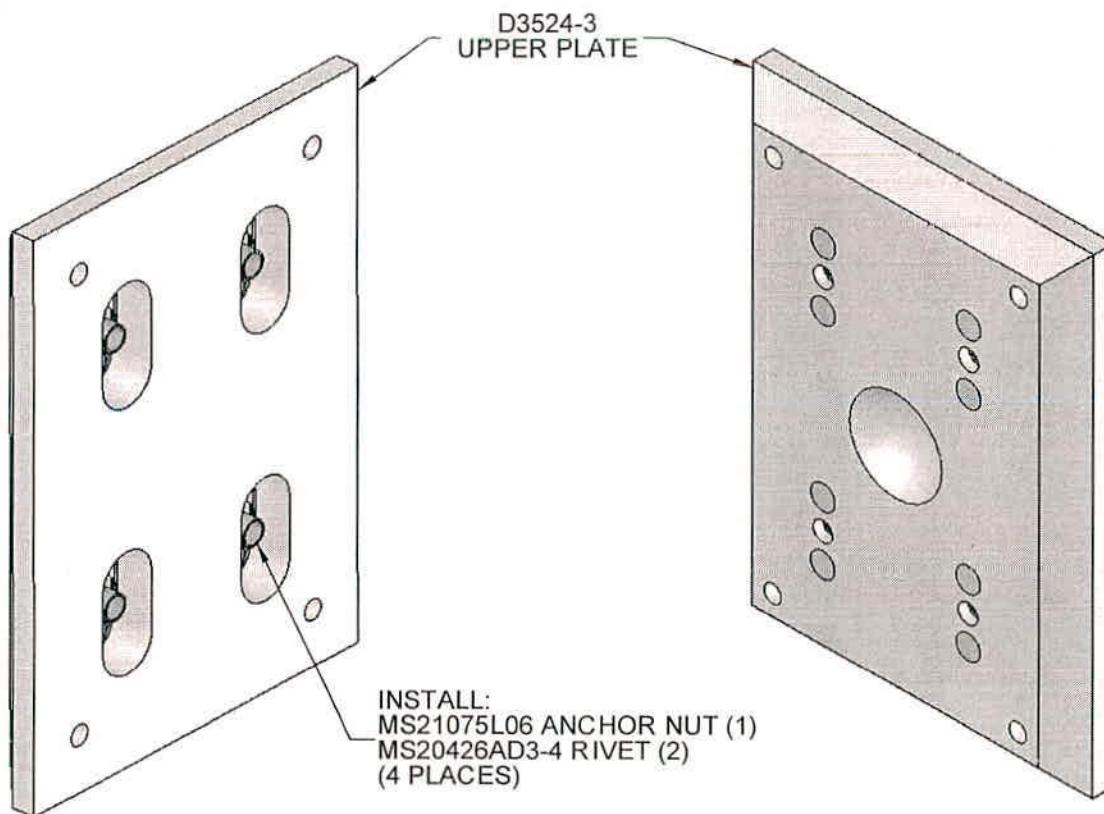
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CHECKED CE	APPROVED <i>[Signature]</i>	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1

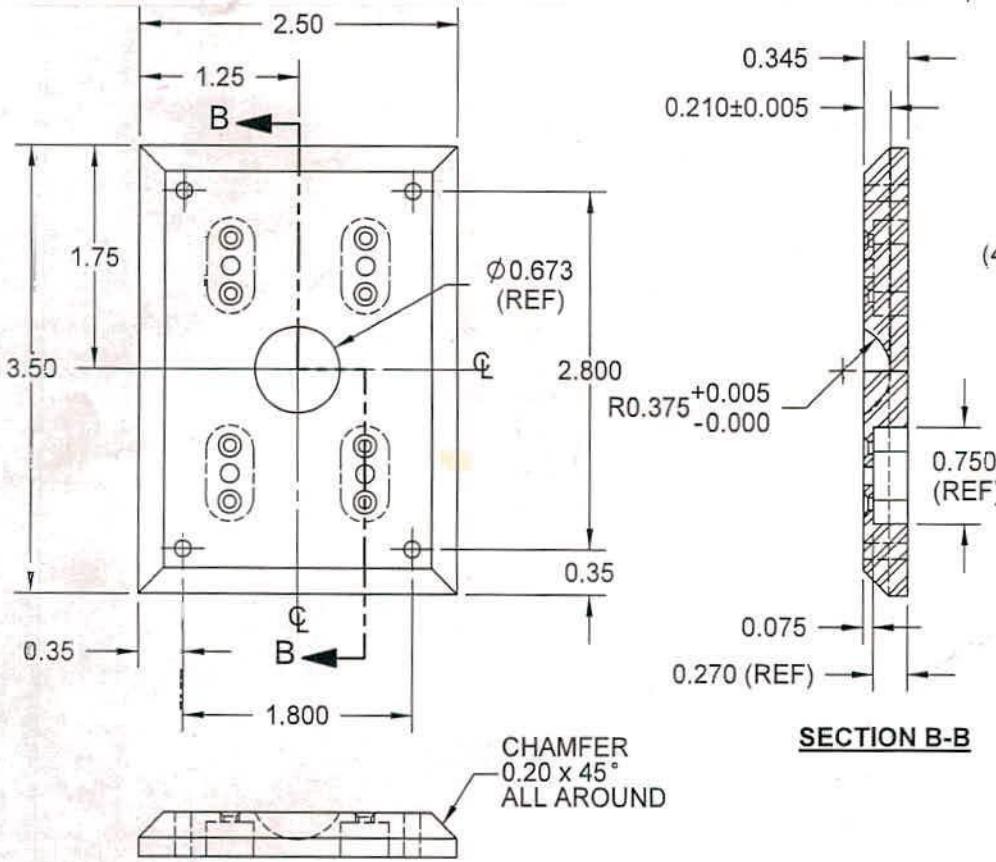
D3524-041 UPPER PLATE ASSEMBLY**RELEASED**  
07.08.03 *[Signature]*PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

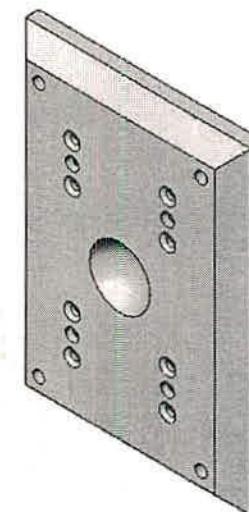
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## D3524-3 UPPER PLATE



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
  - 6) PART SYMMETRIC ABOUT  $\mathbb{C}$

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DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b>	
C B	C B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
C E	H	D3524	SHEET 3 OF 3
DATE	TITLE	SCALE	
07.07.24	UPPER AND LOWER PLATE	2:3	



DART AEROSPACE LTD	Work Order:	34824
Description: UPPER PLATE	Part Number:	D3524-3
Inspection Dwg: D3524 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection*	Comments
2.50	± .030	2.500	—			
1.25	± .030	1.250	—			
1.75	± .036	1.750	—			
3.50	± .030	3.502	—			
0.35	± .030	0.350	—			
1.800	± .005	1.800	—			
0.35	± .036	0.350	—			
2.800	± .005	2.800	—			
0.20X45°	± .030	0.187X45°	—			
0.345	± .016	0.347	—			
0.210	± .005	0.210	—			
R0.375	± .005	R0.375	—			
0.075	± .016	0.077	—			
0.375	± .016	0.376	—			
Ø0.144	± .004	Ø0.145	—			
0.218	± .005	0.218	—			
Ø0.129	± .004	Ø0.130	—			
1.063	± .005	1.063	—			
0.72	± .030	0.719	—			
0.94	± .036	0.940	—			
1.625	± .005	1.625	—			
Ø0.098	± .004	Ø0.099	—			

Measured by:	MJL	Audited by:	JF	Prototype Approval:	alv
Date:	07/10/08	Date:	07/10/08	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

